

Date: Thursday, 24/07/2008 2:37:14 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 03.250 SUPPORT
Job Number : 40753
Estimate Number : 10387
P.O. Number : Part Number : D29401
This Issue : 24/07/2008 S.O. No. : Drawing Number : D2940 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : // Type : MACHINED PARTS Drawing Revision : B
Previous Run : 39685 Material :
Written By : Due Date : 04/08/2008 Qty: 20 Um: Each
Checked & Approved By : JULIE 08.7.24
Comment : Est. C 02.11.26 Reformat; Added P/O KJ
Est Rev:D Added priming as per Rev B 07-04-30 JLM
est E 08.03.19 Re-format Ec verified by DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DSK081

D2940-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2940-1 TURNING DETAIL

Batch: B40801

H.A 08/08/16

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1- Machine as per Folio FA079

2- Tumble & Deburr

8/08/19

H.A 08/08/16

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

H.A 08/08/16

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

H.A 08/08/25

5.0

POWDER COATING

POWDER COATING



M1108523



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
400°F
10:45

M. 08/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/07/2008 2:37:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 40753

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

ml 08 08 26 (20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08 08 26 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

ml 08 08 28

(20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20)
08 08 28

Job Completion



08 08 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40153
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.153	0.153	0.156	0.156	0.154
AD	3.510	3.530		3.512	3.510	3.514	3.520	3.517
AE	1.633	1.673		1.650	1.647	1.654	1.652	1.652
AF	1.493	1.513		1.499	1.499	1.500	1.500	1.497
AG	0.040	0.060		0.056	0.056	0.050	0.050	0.049
AH	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AI	0.140	0.160		0.145	0.149	0.148	0.150	0.147
AJ	2.518	2.538		2.525	2.524	2.521	2.523	2.526
AK	0.040	0.060		0.052	0.052	0.053	0.053	0.053
AL	0.010	0.020		0.013	0.013	0.013	0.013	0.013
AM	0.140	0.160		0.152	0.152	0.153	0.153	0.153
AN	0.350	0.450		0.377	0.388	0.377	0.377	0.377
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.150	0.150	0.150	0.155	0.154
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.129
AV								
AW								
Accept/Reject								

Measured by: H.A. Date: 08/08/16

Audited by: SA Date: 08/08/16

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40753
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	.250	.250
AB	0.490	0.510		0.500	0.500	0.500	.500	.500
AC	0.140	0.160		0.154	0.153	0.153	.153	.153
AD	3.510	3.530		3.518	3.518	3.518	3.517	3.517
AE	1.633	1.673		1.654	1.654	1.654	1.654	1.654
AF	1.493	1.513		1.504	1.504	1.504	1.500	1.505
AG	0.040	0.060		.049	.050	.050	.050	.050
AH	0.188	0.193		0.189	0.189	0.189	.188	.188
AI	0.140	0.160		0.149	0.150	0.150	.150	.150
AJ	2.518	2.538		2.526	2.525	2.525	2.520	2.520
AK	0.040	0.060		.053	.052	.052	.050	.050
AL	0.010	0.020		.013	.013	.013	.015	.015
AM	0.140	0.160		0.153	0.152	0.152	.150	.150
AN	0.350	0.450		0.377	0.377	0.377	.376	.376
AO	0.240	0.260		0.250	0.250	0.250	.250	.250
AP	0.150	0.170		0.153	0.155	0.155	.155	.155
AQ	0.053	0.073		0.063	0.063	0.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	.260	.260
AT	0.053	0.073		0.063	0.063	0.063	.063	.063
AU	4.118	4.138		4.129	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by:	H.A. / J.F.	Date:	08/08/17/08/08/19
Audited by:	J.A.	Date:	08/08/25
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40753
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.160	.160	.160	.160
AD	3.510	3.530		3.528	3.528	3.528	3.528	3.530
AE	1.633	1.673		1.653	1.653	1.653	1.653	1.653
AF	1.493	1.513		1.495	1.500	1.500	1.500	1.500
AG	0.040	0.060		.050	.050	.050	.050	.060
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.147	.150	.150	.150	.150
AJ	2.518	2.538		2.522	2.522	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.250	.250
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.149	.150	.147	.147	.147
AN	0.350	0.450		.388	.388	.388	.388	.388
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.169	.169	.167	.167	.167
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by:	SS	Date:	08/04/20
Audited by:	SA 08/08/20	Date:	
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40753
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	#17	#18	#19	#20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.159	0.158	0.159	0.159	0.159
AD	3.510	3.530		3.519	3.520	3.521	3.526	3.527
AE	1.633	1.673		1.653	1.654	1.654	1.657	1.657
AF	1.493	1.513		1.499	1.496	1.497	1.501	1.499
AG	0.040	0.060		0.050	0.048	0.045	0.051	0.046
AH	0.188	0.193		0.188	0.189	0.189	0.189	0.189
AI	0.140	0.160		0.147	0.147	0.148	0.149	0.148
AJ	2.518	2.538		2.525	2.525	2.524	2.523	2.525
AK	0.040	0.060		0.052	0.051	0.051	0.049	0.053
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.150	0.149	0.149	0.150	0.149
AN	0.350	0.450		0.387	0.387	0.380	0.381	0.386
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.153	0.158	0.157	0.155	0.158
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: H.A. 08/08/21 Date: 08/08/21

Audited by: SA Date: 08/08/21

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

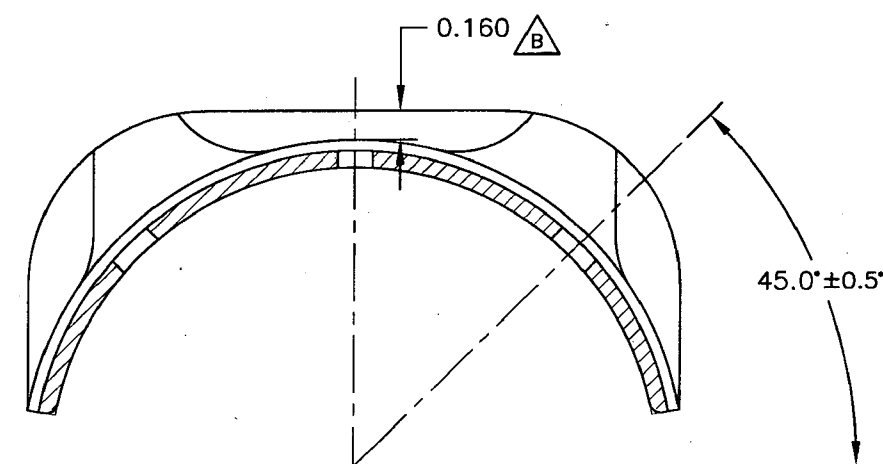
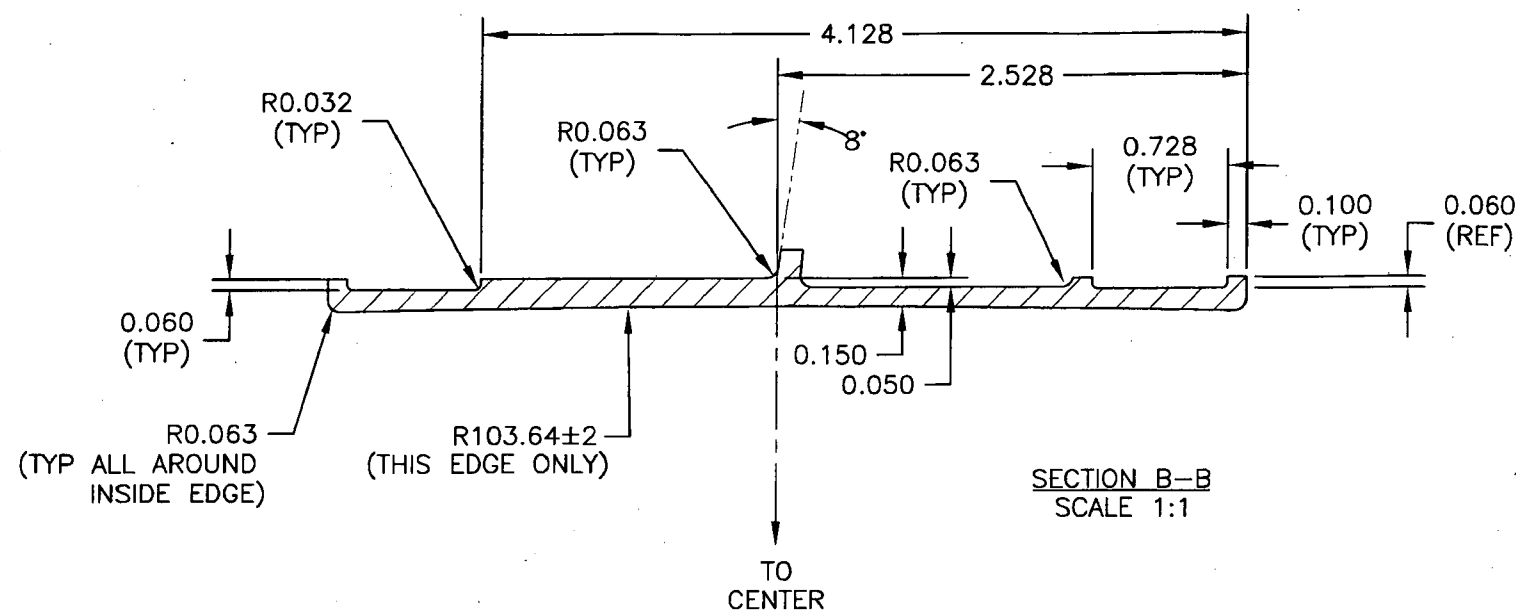
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

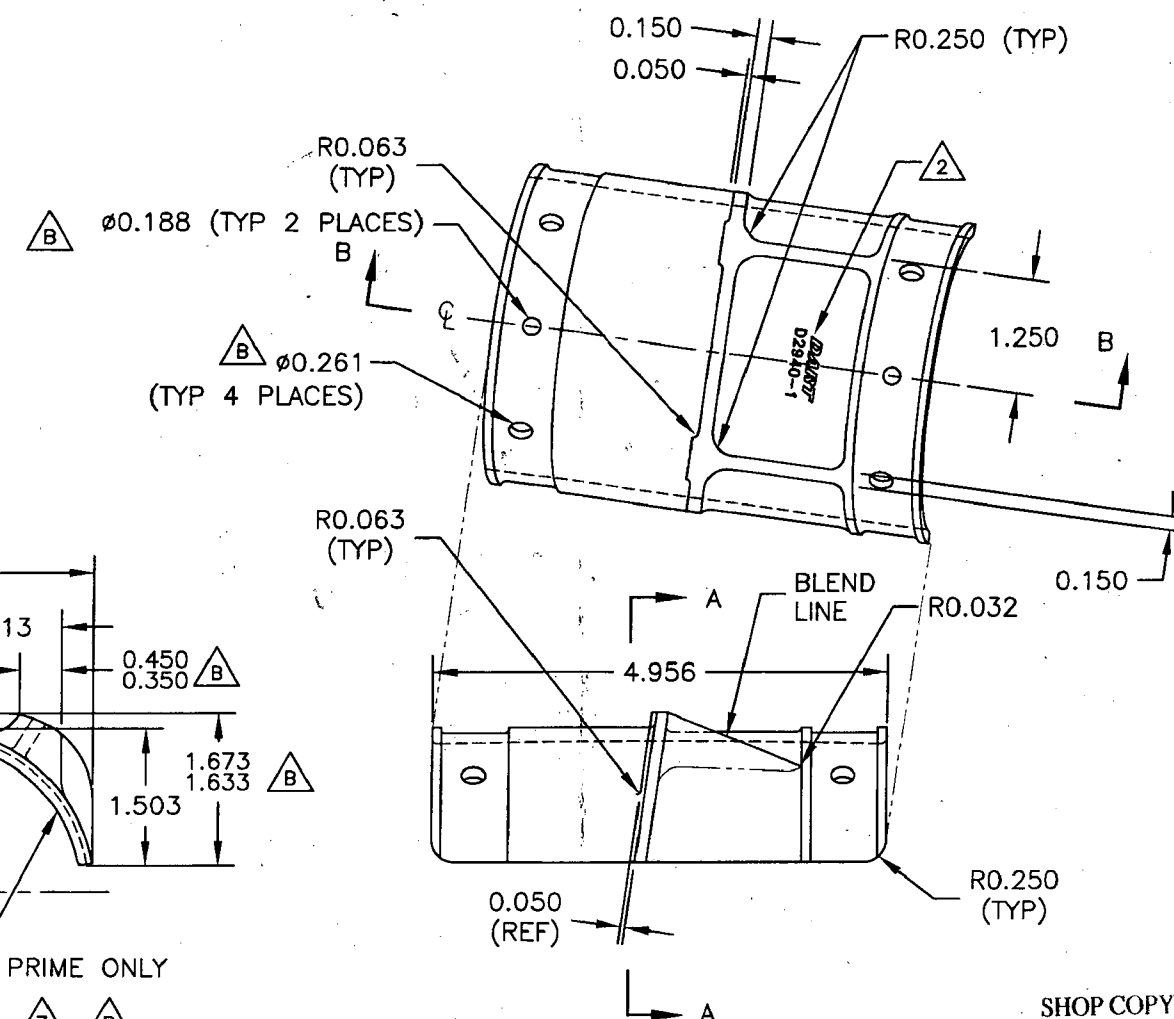
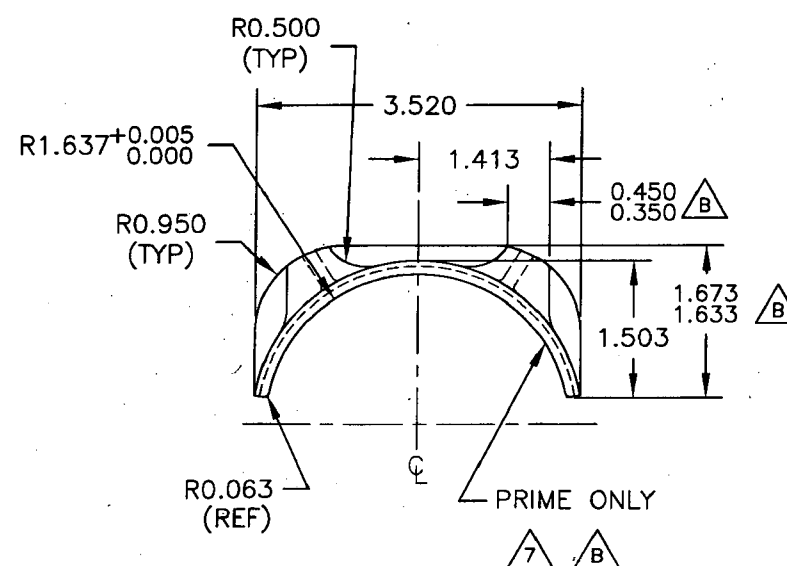
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
 07.04.24 UP
 PER ECN 887



SECTION A-A
 TOOLING HOLE DETAIL
 SCALE 1:1



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 40755

D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
 WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2940
DATE	07.03.16	TITLE Ø3.250 SUPPORT
		REV. B SHEET 1 OF 1 SCALE 1:2

